

Work Order ID 73663

Monday, September 12, 2011 10:14:16 AM



ASAP

Page 1

Item ID: D3340-7

Accept



Setup Start



Revision ID:

Item Name: Fwd Skidtube Protector

Stop



Start Date: 9/12/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 11-09-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3340

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3340
Deburr if necessary

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-

B11-9-13

5

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-9-13

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subor 13

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr if necessary Form on brake as per Dwg D3340 using Jigs DT⁸³²⁴ Ss ulor/13 and DT 8261

(S)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S ulor/13

(+S)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

320°F

9:40

5x of m-l ulor/14

m 117338

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Page 3

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

route

2 times used
S

Jul 11/09/10

170

Identify as per dwg & Stock Location:

Yif

0.00



Packaging

Memo

0.00

Packaging

Comp/14/8

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/14

MF 11-09-14

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Picklist Print

Monday, September 12, 2011 10:14:14 AM

Page 1

Work Order ID: 73663



Parent Item: D3340-7



Parent Item Name: Fwd Skidtube Protector



Start Date: 9/12/2011

Required Date: 9/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A 05.11.10 Preliminary issue AP/EC
IPP Rev:B Now on Waterjet 06-09-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA  1010/1025 SHEET		Purchased	No			100	sf	150.5000	0.889	3.743158	4.4		
											131-9-13		

Location

Loc Qty

Loc Code

MAT019

150.5

111410

64

116791

86.5

111410

5

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DART AEROSPACE LTD		Work Order: 73665
Description: Fwd Skidtube Protector		Part Number: D3340-7
Inspection Dwg: D3340	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250 x 0.300	+/-0.010	0.259 x 0.306	2		V B01	
0.50	+/-0.030	0.498	2		✓	
0.250	+/-0.010	0.248	2		✓	
1.625	+/-0.010	1.626	2		✓	
2.815	+/-0.010	2.811	2		✓	
2.315	+/-0.010	2.311	2		✓	
1.815	+/-0.010	1.813	2		✓	
22.780	+/-0.010	22.780	1		T B01	
26.280	+/-0.010	26.286	2		T	
34.655	+/-0.010	34.655	1		T	
38.155	+/-0.010	38.155	2		T	
40.355	+/-0.010	40.358	1		T	
43.855	+/-0.010	43.858	2		T	
45.730	+/-0.010	45.730	2		T	

Measured by: RB	Audited by: J	Prototype Approval:	N/A
Date: 11-9-13	Date: 11/08/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	AS

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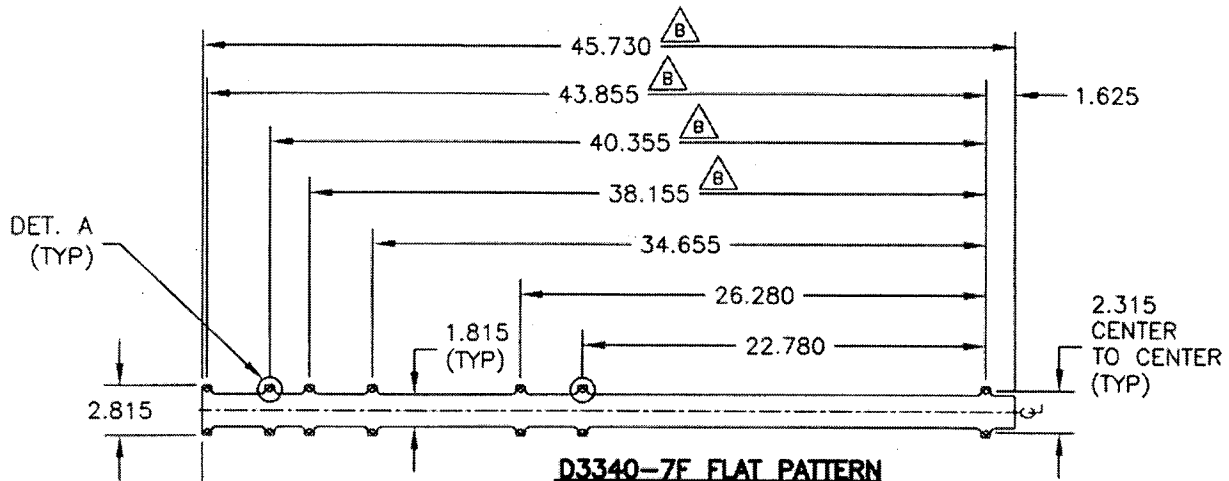
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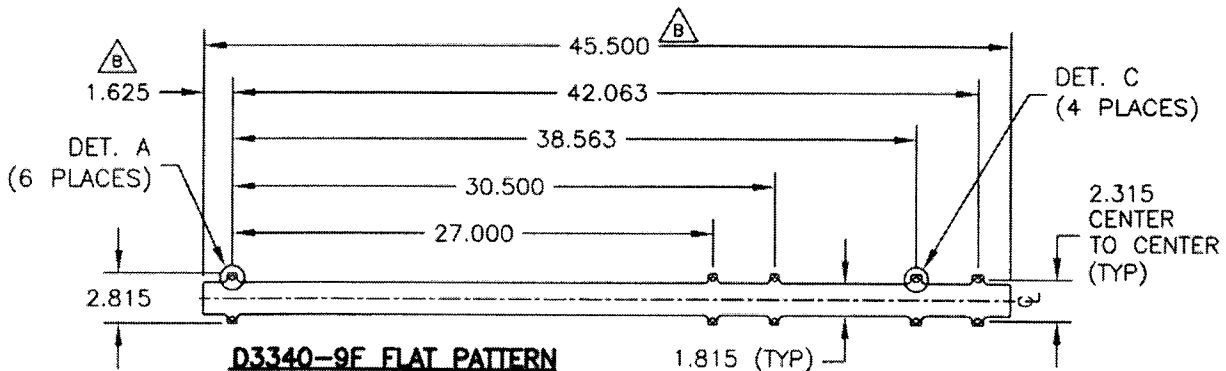
NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3340	REV. B SHEET 4 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



D3340-7 FORWARD SKIDTUBE PROTECTOR



D3340-9F FLAT PATTERN

D3340-9 AFT SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

RELEASED
05.11.28

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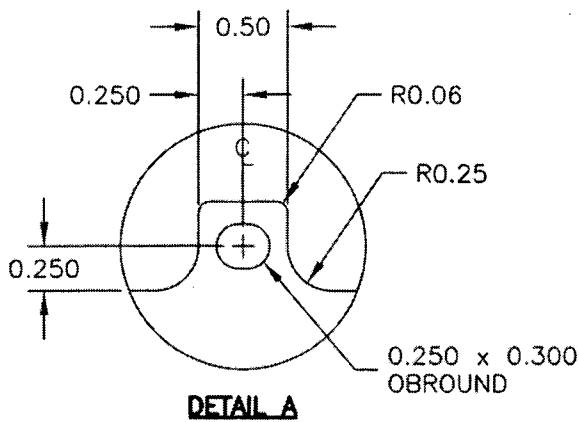
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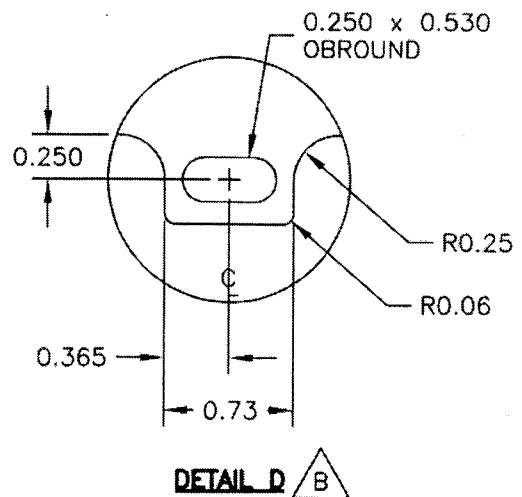
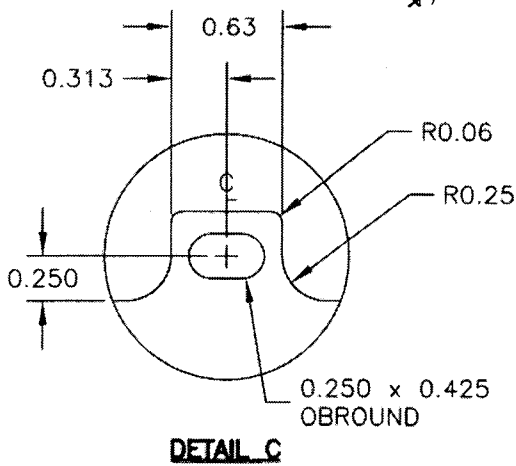
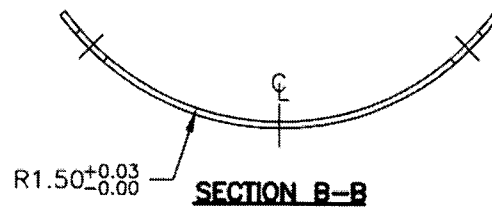
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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3340	REV. B SHEET 11 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1



RELEASED
05-11-28 #



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